

Date: Thursday, 21/08/2008 5:12:15 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GUSSET
 Job Number : 41553
 Estimate Number : 13379
 P.O. Number :
 This Issue : 21/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run : 39959
 Part Number : D344011
 Drawing Number : D3440 REVA
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 18/09/2008 Qty: 30 Um: Each
 Written By :
 Checked & Approved By : JD 08.8.22
 Comment : Est Rev:A 08-06-18 new issue DD verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0250X06000 6061-T6 Bar .250 x 6.00



Comment: Qty.: 0.1805 f(s)/Unit Total : 5.4149 f(s)
 6061-T6 Bar .25" x 6.0" 109025 HB 8-9-10

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3440
 Dwg Rev: A
 Prog Rev: A

HB 8-9-10

(40)

2-Deburr if necessary HB 8-9-10

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-9-10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

56/09/00

410

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: NA

08.09.22

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 21/08/2008 5:12:15 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUSSET

Job Number: 41553

Part Number: D344011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/23 Jf

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

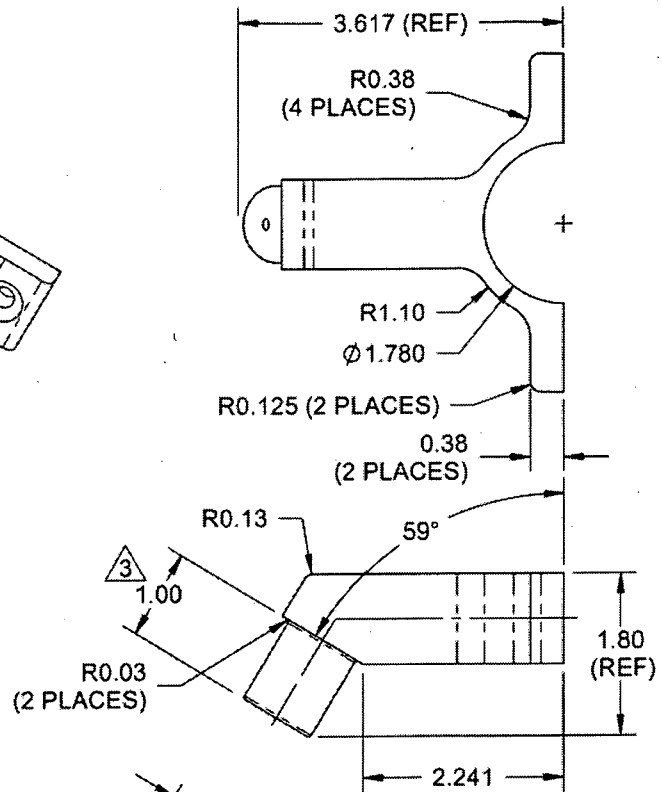
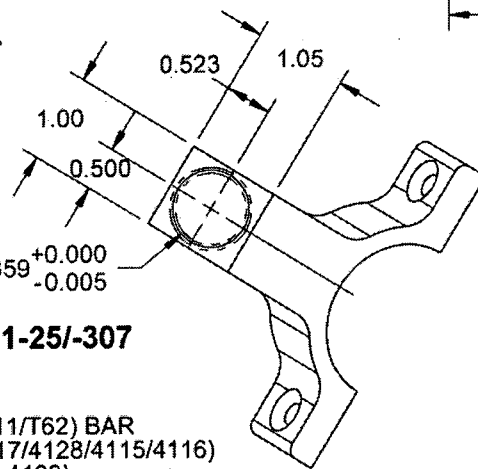
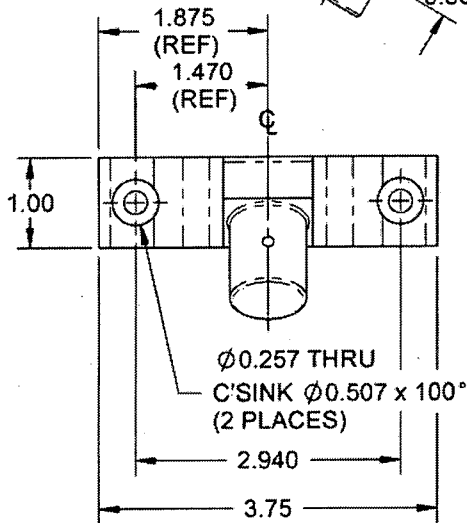
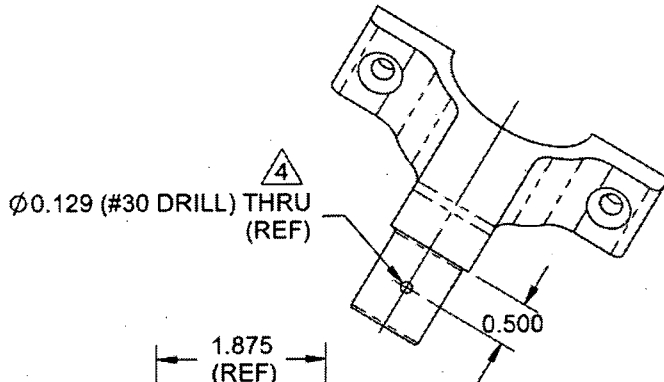
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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05/09/18

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3440	REV. A SHEET 1 OF 7
DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:2
A	05.06.02	NEW ISSUE	

**D3440-1 TUBE GUIDE****SUPERSEDES PREMIER P/N B67-43001-25/-307****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QT-A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) MASK BEFORE PAINTING.
- 4) DRILL HOLE AT ASSEMBLY.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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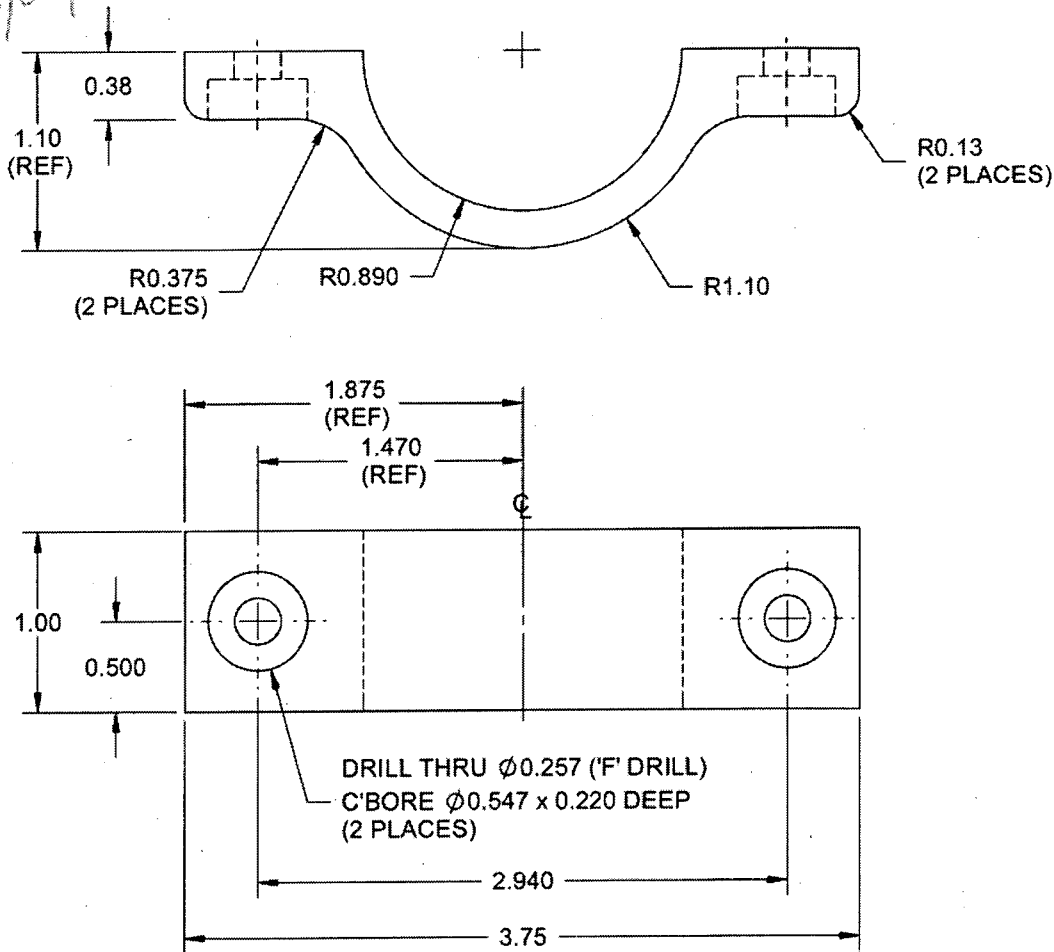
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1

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**D3440-3 CLAMP****SUPERSEDES PREMIER P/N B67-43001-309****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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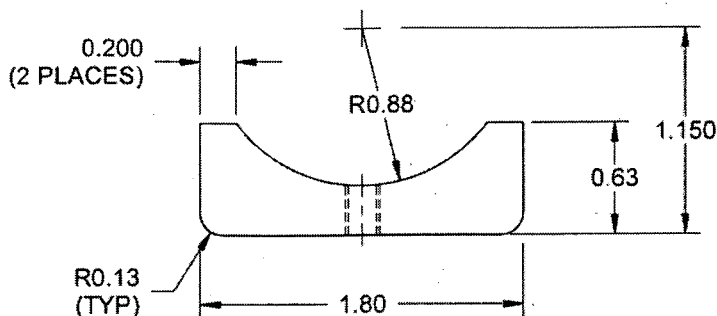
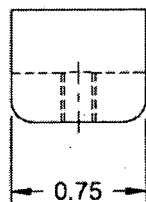
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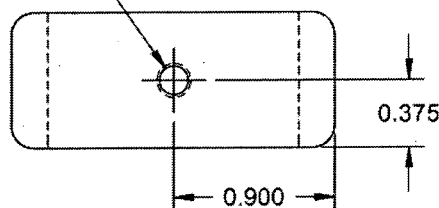


DESIGN 3	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1

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05/08/18



DRILL $\phi 0.159$ THRU,
TAP #10-32 UNF THRU



D3440-5 CONTOURED DETENT CLIP BASE
SUPERSEDES PREMIER P/N B67-43001-217

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/6511/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QT/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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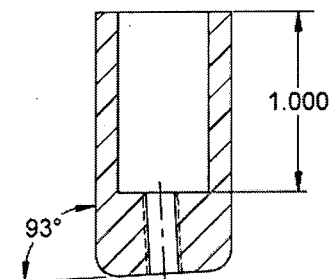
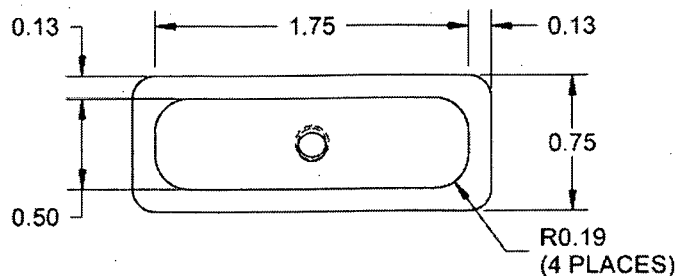
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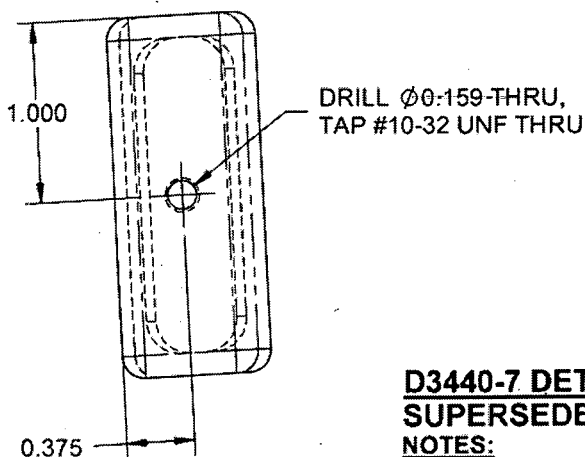
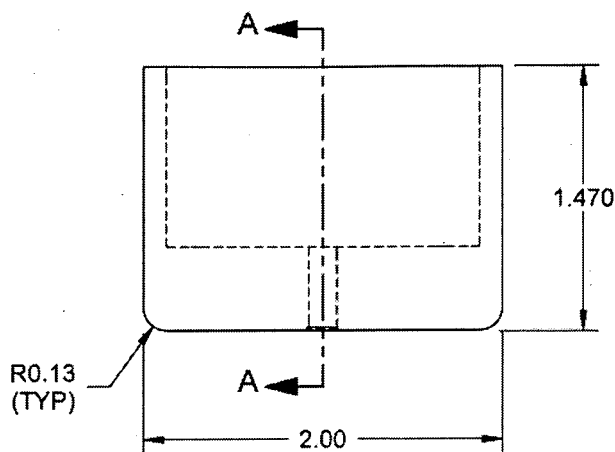


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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1

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SECTION A-A



D3440-7 DETENT CLIP BASE
SUPERSEDES PREMIER P/N B67-43001-221

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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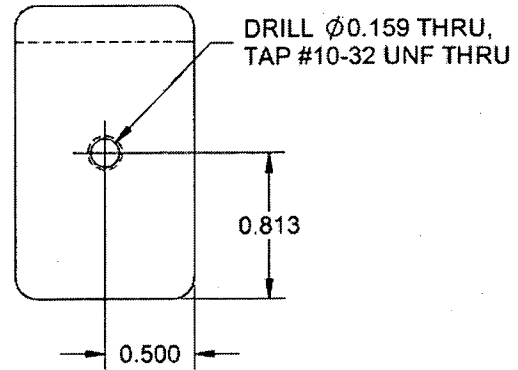
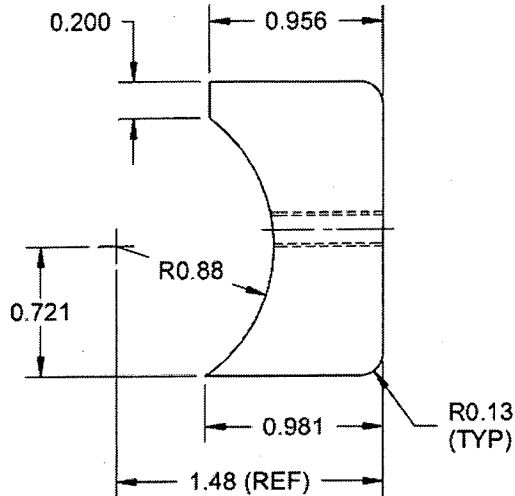
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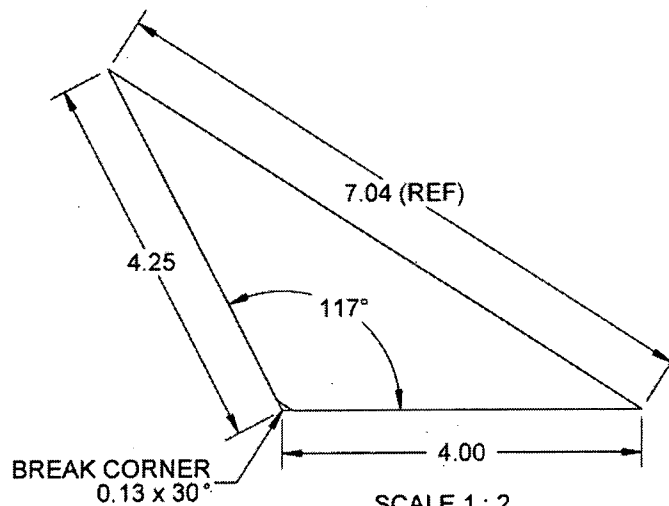
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1



D3440-9 TUBE DETENT CLIP BASE
SUPERSEDES PREMIER P/N B67-43001-241

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)

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SCALE 1:2

D3440-11 GUSSET

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.250)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

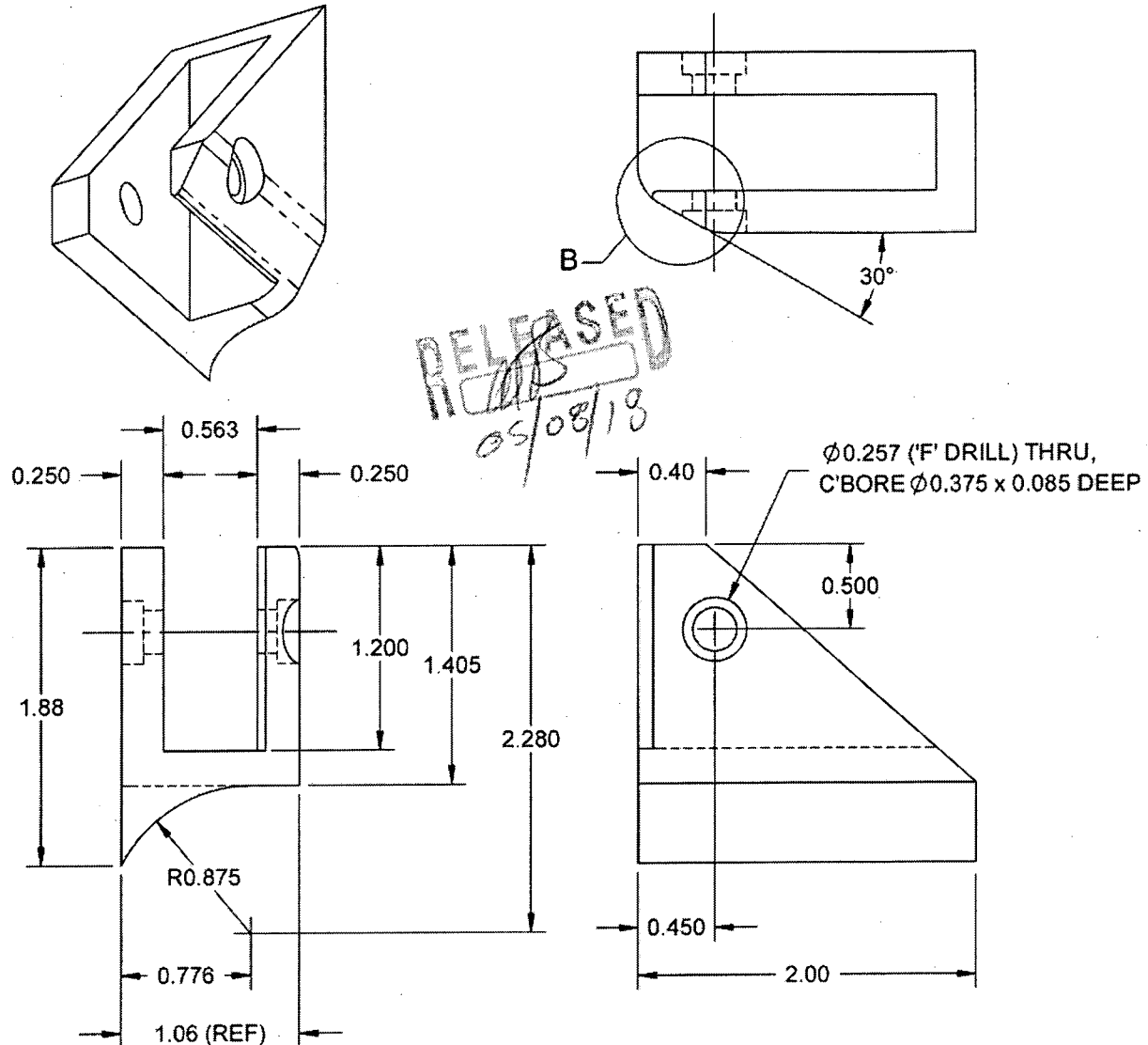
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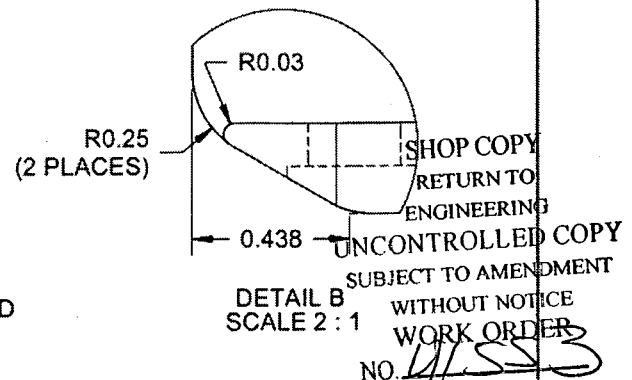
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1



D3440-13 BRACKET
SUPERSEDES PREMIER P/N B67-43001-273

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



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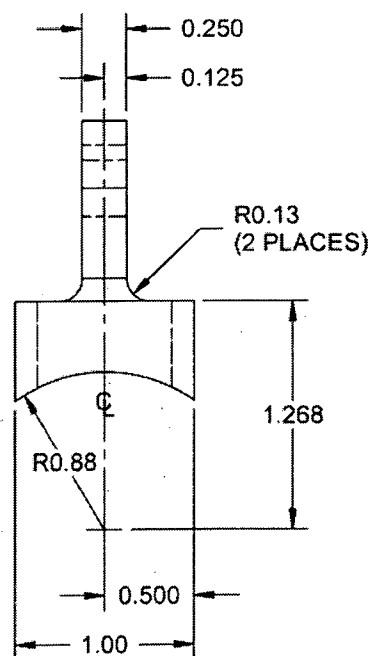
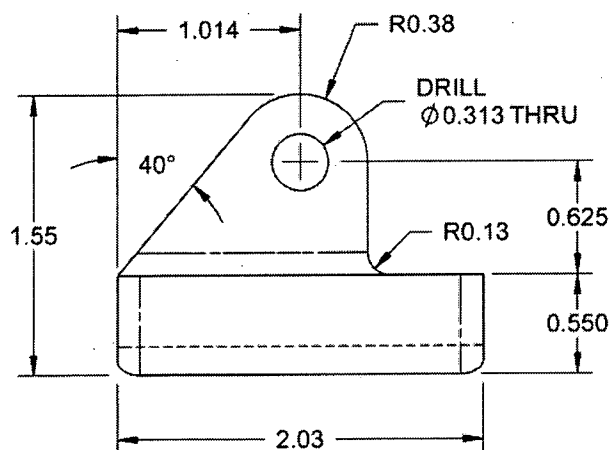
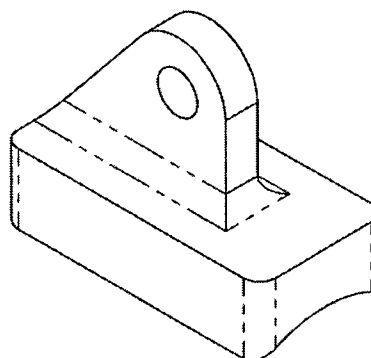
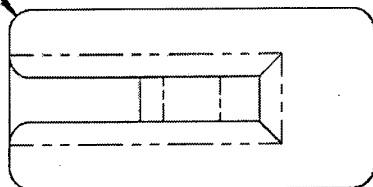
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DATE 05.06.02	TITLE BLADE FOLD KIT PARTS		SCALE 1:1

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05/08/18

R0.13
(4 PLACES)



D3440-15 CONTOURED MALE EYE
SUPERSEDES PREMIER P/N B67-43001-215

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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